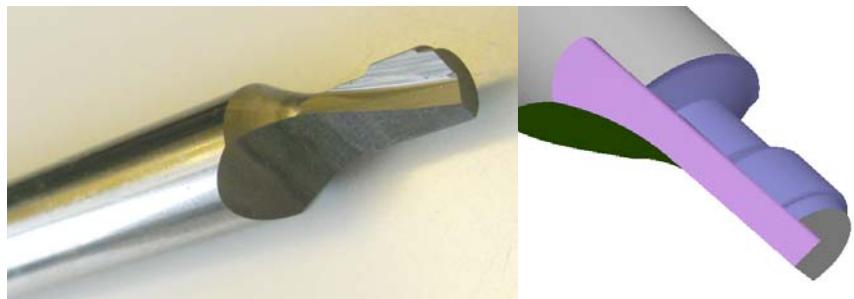


ID-Turning Tool Ø10 Z1

A17-010

The profile of ID-Turning Tools can be ground using either the surface type CS 1 CAM or CS 1 CYL from DXQ Profilegrinding option. The advantage of CS 1 CAM: Turning tools with additional clearance angles can be ground.



1. Cycletime for production

Toolspecifications

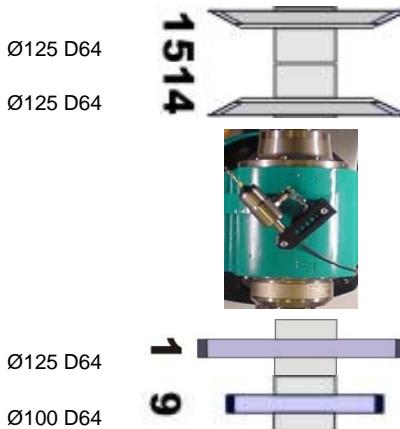
Diameter 10 mm, Cutting edges 1, Length of cutting edge 12 mm, Helix angle 0.001 deg

Material HM

Operations	Probe	Flute 1	Flute 2	Prf Rough	Prf Pregr	Prf Cyl	1 150 Red. from shank
Feed [mm/Min]	2000	60	100	30	40	3	100
Power [kW]		4	2	2	1	1	1
Cutting feed [m/s]		18	18	22	24	22	24
Used wheels		9	9	1	9	15	14
Grinding time [s]	14	31	22	162	114	360	44
Total cycle time	12 Min 27						

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

2. Used grinding wheels



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG

Control: Fanuc 31i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 5

responsible engineer: O.Pellegrini, 22.01.07

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY
FOR TOOLING